

Date: Wednesday, 23/07/2008 11:28:36 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)
Job Number	: 40718		
Estimate Number	: 10258		
P.O. Number	:	Part Number	: D2332041
This Issue	: 23/07/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2332
First Issue	: / /	Project Number	: N/A
Previous Run	: 39332	Drawing Revision	: C
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 30/07/2008
Checked & Approved By	: <u>JLD 08.7.23</u>	Qty:	27 Um: Each
Comment	Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF Est Rev: C- 08-06-02 add comment DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304TR1000WO49	304 RD Tube 1.00 x .049W
-----	----------------	--------------------------



Comment: Qty.: 0.4331 f(s)/Unit Total: 11.6944 f(s)
 Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch M108756

EP 08/08/11

Batch

2.0	M304R250	304 SS Round bar .250
-----	----------	-----------------------



Comment: Qty.: 0.1092 f(s)/Unit Total: 2.9484 f(s)
 Material: Ø0.250" 304SS Rod
 Batch M107389

EP 08/08/11

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

3

EP 08/08/11

(28)

4.0	M304TR0500W035	304 RD Tube .500 x .035W
-----	----------------	--------------------------



Comment: Qty.: 1.2502 f(s)/Unit Total: 33.7564 f(s)
 304 RD Tube .500 x .035W

M108215 (28) M107166 (52)
M107967 (11) M107403 (13)

EP 08/08/11 (27)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 23/07/2008 11:28:36 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 40718

Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 08/08/12

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)
2-ensure no foreign objects inside of tube and deburr

SB 08/08/11

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/13

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)
***** insure nothing is inside of tube before welding*****

L 28

A/R SS Rod Batch: M107057

*****brush weld right after welding, to take color off*****

L2 8-8-19

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-20

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1



1-Tumble

2-Assemble as per Dwg D2332

SB 08/08/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041* PAR #: N/A Fault Category: Proced/Lng Sub NCR: Yes No DQA: 11 Date: 08.08.22
D350-607 welding. QA: N/C Closed: 11 Date: 08/08/22

NCR: 40718		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/20	#100	During inspection 2 Parts were found with forgings. Part(s) inside. 2.c. Parts were not checked 100% inside		SCRAP and Destroy no Replace Qty (X) D2332-13	EL 8.8.20	S 08/08/20		S 08/08/20

NOTE: Date & initial all entries

Date: Wednesday, 23/07/2008 11:28:36 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 40718

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 27.0000 Each(s)

Pick:

Qty Part Number Description
1 AN4-4A Bolt

Batch

M106918

08/08/21

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 81.0000 Each(s)

Pick:

Qty Part Number Description
3 AN960JD416L Washer

Batch

M108583

08/08/21

14.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 27.0000 Each(s)

Pick:

Qty Part Number Description
1 MS21042L4 Nut (or -4)

Batch

M107499

08/08/21

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/21 *counted* **(x26)**

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST203

08/08/21 **(x26)**

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



08-08-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

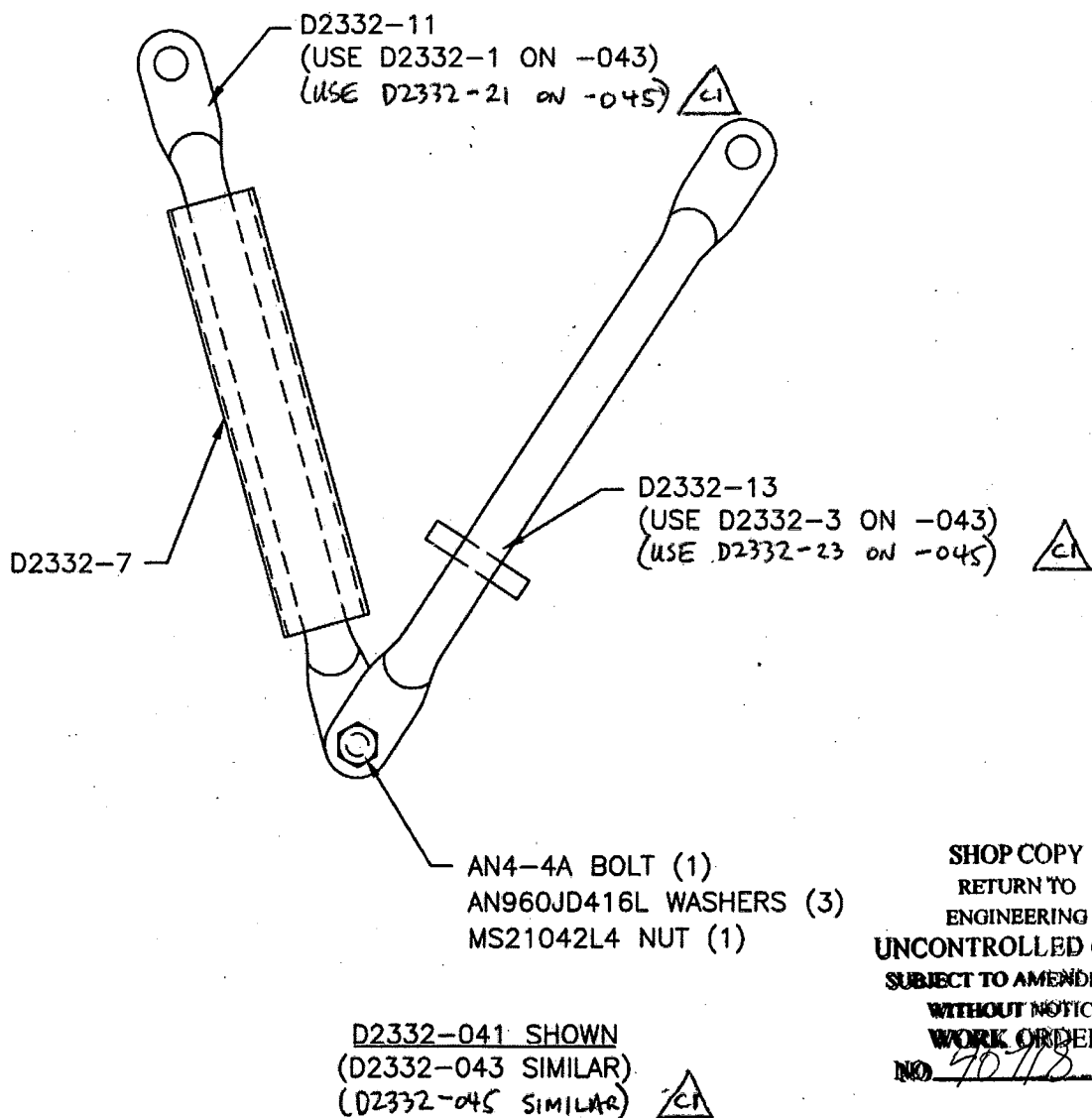
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03	TITLE LOD PROP ASSEMBLY		SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 90718

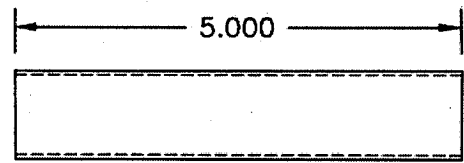
Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

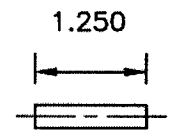
DART

ISSUED TO

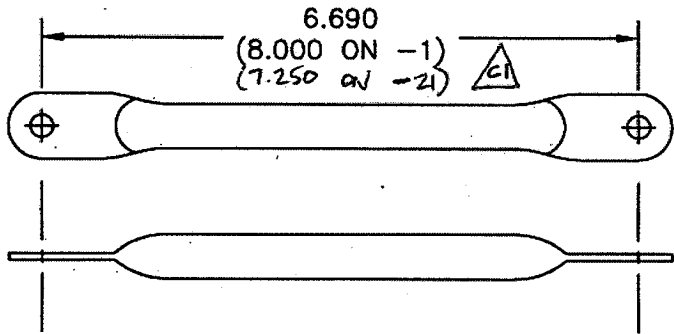
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	TITLE LID PROP ASSEMBLY	REV. C
	DRAWING NO. D2332	SHEET 2 OF 2
	SCALE 1:2	
C	03.07.03	MAKE -011 PROP 6.69" LONG (LTD)
C1	03.08.06	MAKE -043 PROP 8.00" LONG (LTD)
		ADD -045 PROP (7.25" LONG)



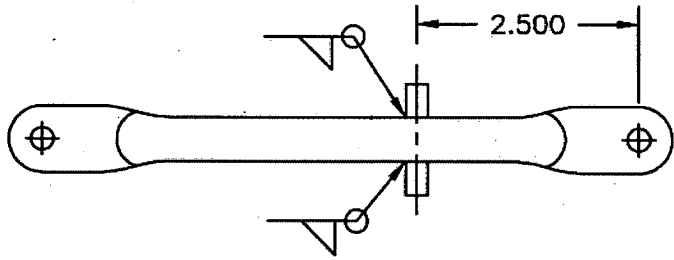
D2332-7 LOCKING COLLAR



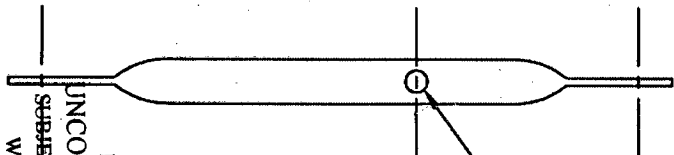
D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5



DRILL 1/4 HOLE FOR D2332-5

WORK ORDER
NO. 40768
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING
D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

- NOTES:
- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
 - TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04